Work Orde January-30-14 1		2606		*112	26063								Page 1
Item ID: Revision ID:	D3556-1			Accept	*N9	იი	<u>040</u>	100)* s	etup	Start	*N	S1*
	Clamp For R44	4 Bearpaw	•								Stop	*N:	S2*
Start Date: Required Date: Reference:	1/30/14 1/30/14	Start Qty: 20.00 Req'd Qty: 20.00	, , ,		Cust 1	1	ID:						
Approvals:	Process Plan	n: <u>M</u> L5	Date: / <i>Y-()</i> Z -	2 3 Tooling: SPC (Y/N):			ate:	-	R		Start Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Тоо	l ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr											
D3556	Rev	В											
100		PURCHASING		0.00					48		3	-	Jm 14-03-3
Waterjet FLOW CNC Waterje		Memo 1-Cut as p prog rev:_ dwg rev:_	er dwg D3556	0.00									
		2-Deburr										,	
¹¹⁰ ★11 ↑		QC2- Inspect parts off	machine FAI/FAIB	0.00					48	"			Im14-03-3

0.00

Memo

Quality Control

DQA:	Date:					WORK ORDER NON-CONFORMANCE / UPDATE										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP				–	_	AEROSPACE	
QA Closed:			Date:								Wo	ork Order up	odate only			
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS			
	•					Rework			Skid-tube	Crosstube			Water Jet	٦	Engineering	
Part I	٧o.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality	
	-	4,4				Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other	
NCR I	۱o. ₋					Suspected Unapproved			Large Fab	Composite			Supplier			
Root					Desc	ription of work order update		nitial	Acti	on		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification		QC Inspector	
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							FA	ULI CA	TEGORY							
Landi	ng (ı				General		150150	Dragram			Outside Dim	Г		Pressure/Forced	
	┝	Bending	- . C		\vdash	Bend BOM/Bouto	-	1	Program			4	<u>-</u>	_		
	┢	Centre No	ot Concer	ntric	_	BOM/Route	\vdash	Grain			_	Over/Under Part Incorre	-		Set-up Temperature/Cure	
	\vdash	Cracks	ale/Diamla	Malaria		Broken/Damage/Defect		Hardwa		auglified		1	 -	_	Weld	
!	-	Crimp/Kir	ік/кірріе	y wave	\vdash	Burrs		1 '	tion Incomplete/Un	-	_	Part Lost/Mi Part Moved	· -			
	<u> </u>	Crushing			\vdash	Countersink	-	4	tions Incomplete/U	inclear	-	1			Wrong Stock Pulled	
	-	Crushing Heat Trea	.+		-	Countersink Cut Too Short	-	Mislab	gned/off center			Positioned V Power Loss/	, ,		Other	
	\vdash	Inspection		Tubo	-	Drawing	-	Misrea			L	Jrower Loss/	Juige [Other	
1	\vdash	Marks/Ch		rube	-	Drill Holes	-	Off-set				-				
	\vdash	Turning S			 	Finish	\vdash	-1	Calibration							
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Work Orde January-30-14		2606		*11	26067	k						Page 2	
Item ID: Revision ID: Item Name:	D3556-1 Clamp For R4	4 Bearpaw		Accept	*N9(ገበር	14010)()*	Setup S	Start Stop	*N!	S1* S2*	
Start Date: Required Date: Reference:	1/30/14 : 1/30/14	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust I Custo	tem ID: mer:	:						
Approvals:		n:	Date:	Tooling: SPC (Y/N):		_ Date				Start Stop	*NI	R1* R2*	
Sequence ID/ Work Center II 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hours 0.00 27 5-89 0.00 1	Tool	ID	Tool # Plan Cod		t Rejec Qty		Reject Iumber	Insp. Stamp	
130 *120* Small Fab Small Fab		Small Fab Memo 1- Bend as po	er dwg	0.00			DAS 30 9-89	પ્ક				14/03/1	7
140 *1 40* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 DAS 27 0.00 \$-59	2)18			<u>48</u>					

DQA:	Date:						DART								
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPE				AEROSPACE		
QA Closed:			Date:							<u> </u>	ork Order up	date only			
Work Orde	ar.					DISPOSITION	Ì			AGAINST D	EPARTMENT	PROCESS			
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Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	-				_	Use-as-is	1	ř	noforming	Finishing	-	e/Packaging	Other		
NCR N	lo.					Suspected Unapproved			Large Fab	Composite]	Supplier			
Root	Ţ				Desci	ription of work order update		nitial	Actio	n	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector		
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	_	Bending				Bend] Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
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		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	<u></u>	Temperature/Cure		
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	Inspect	ion Incomplete/Unq	ualified	Part Lost/Mi	issing	Weld		
	-	Cuffs	• •	-		Contamination		4 `	tions Incomplete/Un		Part Moved		Wrong Stock Pulled		
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	 		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other		
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						
		Marks/Cl	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence						

Work Order ID 112606

112606

Page 3

January-30-14 11:51:18 AM

Required Date: 1/30/14

Item ID: Revision ID: D3556-1

Accept

N900040100

Setup Start

Stop

Item Name: Start Date:

1/30/14

Start Qty: 20.00

Req'd Qty: 20.00

20 *20*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____ Date: ____

Clamp For R44 Bearpaw

Date: _____

Tooling:

SPC (Y/N):

Date:

Run

Stop

Sequence ID/ **Work Center ID** Operation **Description**

QC:

Set Up/ **Run Hours**

Tool ID Tool # Plan

Date:

Accept Qty Qty

Code

Reject Reject Number Stamp

Insp.

150

Packaging

150 Packaging

Memo

0.00

0.00

DAS 48x 26 14-03-18

160

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 57457

0.00

160

Quality Control

Memo

0.00

Pl 14-03-19

DQA:	Date:					WORK OPDER NON	cc			LIDDATE				•	DART
QA Closed:			Date:			WORK ORDER NON	-C(JINFUI	RIVIANCE / C		W	ork Order up	date only	٦	AEROSPACE
						DISPOSITION						PARTMENT			
Work Orde	er: _					DI3F03ITION				AGAINST		, <i>-</i> ,		_	
						Rework			Skid-tube	Crosstube			Water Jet	┙	Engineering
Part N	10					Scrap			Machining	Small Fab		1	d. Eng. Coor.	4	Quality
						Use-as-is	1	Thern	noforming	Finishing		Rec/Stor	re/Packaging	4	Other
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ļ	-	Cracks			<u> </u>	Broken/Damage/Defect	-	Hardwa		(), ()C	_	Part Incorre		_	Temperature/Cure
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ŀ	1	Wave/Tw	<u>vist in Tul</u>	pe		Fit/Function		Out of	Sequence						

January-30-14 11:51:18 AM

Work Order ID:

112606

Parent Item:

D3556-1

Parent Item Name:

Clamp For R44 Bearpaw

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A New Issue 07-03-23 JLM

IPP Rev:B 08-07-28 per dwg revb (ecn 08-506) DD verified by:EC IPP Rev C 11.07.14 now in-

house EC verified by:JLM

	nouse no venime.												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	369.0170		9.80	2.0	97 .	11.03
304/316 Sheet .063									C		2.0	سر	<u> 14-03</u> .
				Location		Loc Oty	Lo	c Code					
				MAT020		369.017							
				M126	915	2.487							
				M127	821	166.53			<u></u>				
				M128	054	200			178	054			

DQA:	Date:						WORK ORDER NON-CONFORMANCE / UPDATE									
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					_	AEROSPACE	
QA Closed:			Date:								Wo	ork Order up	date only			
Work Orde	or.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS			
Work Orac	-''-				—	Rework	ıl		Skid-tube	Crosstube]	Water Jet	٦	Engineering	
Part N	lo.	,				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	┨	Quality	
	•					Use-as-is			moforming	Finishing			re/Packaging	٦	Other	
NCR N	lo. -	•				Suspected Unapproved			Large Fab	Composite			Supplier			
Root					Desc	ription of work order update	ı	nitial	Acti	ion		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	_	QC Inspector	
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Handling/Pre	Ш						١					i i				
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Unapproved			<u> </u>		1		EA	III T CA	TEGORY			<u>. </u>	l			
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		Centre No	nt Concer	ntric		BOM/Route	\vdash	Grain	r togram			Over/Under	-		Set-up	
	H	Cracks	or concer		<u> </u>	Broken/Damage/Defect	\vdash	Hardwa	are		-	Part Incorre	H-	_	Temperature/Cure	
	-	Crimp/Kir	nk/Rinple	/Wave		Burrs		4	tion Incomplete/Un	ngualified		Part Lost/Mi	-	_	Weld	
		Cuffs	Мутирріс	,, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	_	Contamination	\vdash	- d	tions Incomplete/U	•		Part Moved	-	—	Wrong Stock Pulled	
		Crushing				Countersink	\vdash	4	gned/off center		 	Positioned V		_	Ü	
		Heat Trea	at			Cut Too Short		Mislab	-		\vdash	Power Loss/		\neg	Other	
	\vdash	Inspectio		Tube		Drawing		Misrea				·	- L			
		Marks/Cl	•			Drill Holes		Off-set	:							
	Г	Turning S	equence			Finish		Out of	Calibration							
		Wave/Tw				Fit/Function		Out of	Sequence							

DART AEROSPACE LTD	Work Order:	112606
Description: Clamp	Part Number:	D3556-1
Inspection Dwg: D3556 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.257	+/-0.010	0.260			U	12mdi
0.375	+/-0.010	0.377			V	
0.375	+/-0.010	03399			V	
0.75	+/-0.030	0.753	_		V	
0.450	+/-0.010	0450			υ	
6.196	+/-0.010	Ce 196"	-		U	
7.09	+/-0.030	7.094	_		V	
0.063	+/-0.010	0.060	_		J	
		7.00				
			mas			

Measured by: Jm	Audited by:		Preliminary Approval:	
Date: 14-03-3	Date:	14-3-3	Date:	

Rev	Date	Change	Revise	d by	Approved
Α	12.05.14	New Issue	KJ	9XX	
_				77	77

	िहरूक देवें राज्य जिल्हा है सम्प्राह्म <mark>क्षेत्र के हैं</mark> है । क्रिस्त के देवें वें		 	. Link
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112606 MG 1402-0]

SHEET 1 NOTE 1 MATERIAL WAS MIL-S-5019, SHT 2 ZN B1 SLOT LENGTH WAS 0,357 (REF NCR 257). DRAWING TRANSFERD TO "B" SIZE & UPDATED TO CURRENT STANDARDS. AJS 08.07.11 A NEW ISSUE СВ 07.02.13 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B

D3556 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE CLAMP DE APPR. DATE COPYRIGHT © 2007 BY DART AEROSPACE LTD
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NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE, PER MIL-S-5059 (REF DART SPEC M304S16GA)

PER MIL-S-5059 (REF DART SPEC M304S16GA)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N D3556-1 USING FINE POINT PERMANENT
INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
7) PART IS SYMMETRIC ABOUT Q
8) WEIGHT: 0.09 ibs

8

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